

Date: Tuesday, 12/20/2005 3:36:56 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SPACER |
| Job Number | : 25325 | | |
| Estimate Number | : 10001 | | |
| P.O. Number | : N/A | Part Number | : D2213 |
| This Issue | : 12/20/2005 S.O. No. : N/A | Drawing Number | : D2213 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 12/20/2005 Type : MACHINED PARTS | Drawing Revision | : B |
| Previous Run | : 24393 | Material | : N/A |
| Written By | : <u>SEE COMMENT BELOW</u> | Due Date | : 1/20/2006 Qty: 160 Um: Each |
| Checked & Approved By | : <u>SEE COMMENT BELOW</u> | | |
| Comment | : Est Rev: C Turned In-House 05-10-17 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------|-------------------------|
| 1.0 | M6061T6R0750 | 6061-T6 Round Bar .750" |
|-----|--------------|-------------------------|



Comment: Qty.: 1.1000 in(s)/Unit Total : 176.0000 in(s)
 MATERIAL: 6061-T6 Round Bar .750"
 (M6061T6R0750)
 Batch: M19430

Inf 06/01/13

| | | |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL
 1-TURN AS PER FOLIO FA113 & DWG D2213 ,
 FOLIO REV: A
 DWG REV: B

2-DEBURR AS REQUIRED

BC 06.01.19

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 06.01.19 160

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

SA 06.01.19 160

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: 29

CY 06/01/26 159

4.1 Chemical Conversion as per Part QSE 005 4.1 (BAD 06.01.25) 159
 4.2 QC3. Inspected CCC 06.01.25

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 06/01/27
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:36:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 25325

Part Number: D2213

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/27

159

159 06/01/27

Job Completion



Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|--|--|---------------------|--------------------|
| DART AEROSPACE LTD | | Work Order: | <i>25325</i> |
| | | | |
| Description: Spacer | | Part Number: | D2213 |
| | | | |
| Inspection Dwg: D2213 Rev: B | | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

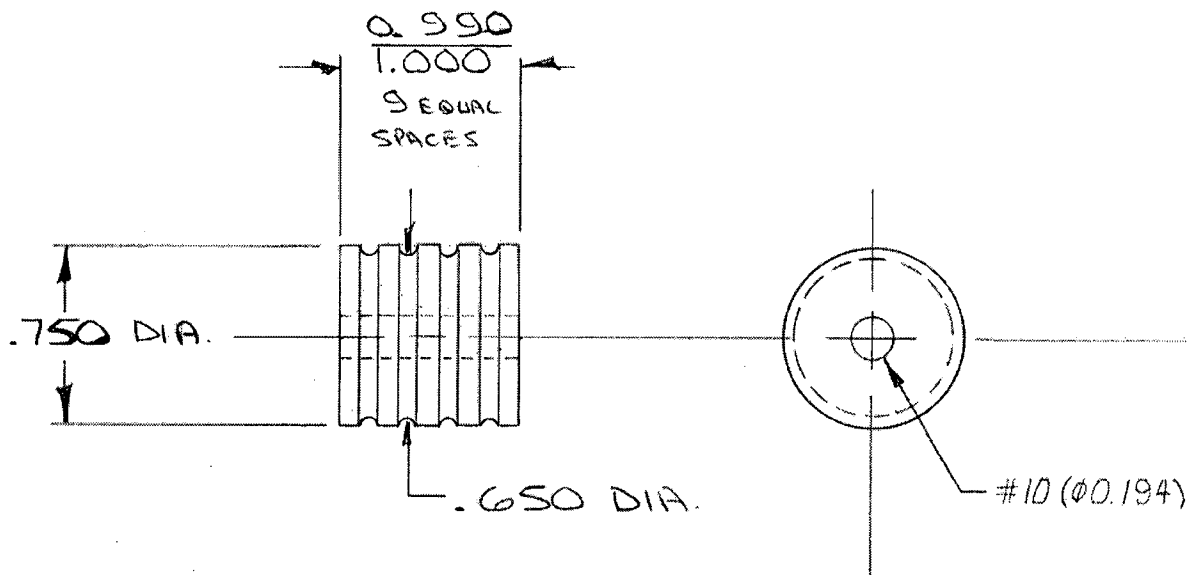
| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | BG | Audited by: | SA | Prototype Approval: | N/A |
| Date: | 06.01.16 | Date: | 06.01.16 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 05.02.17 | New Issue | KJ/JLM | |

DART



| | | | |
|--------------------------|----------|---|--------|
| DRAWN BRADLEY 94.2.9 | | DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| DESIGN BRADLEY 94.2.9 | | DRAWING NO. DZZ13 | REV. B |
| STRESS | | TITLE SPACER | |
| B | 95:08:17 | #10 HOLE ADDED | |



MATERIAL

ALUMINUM ALLOY 2011-T3

CHRONOLOGY
REVISIONS
ENGINEERING
UNCONTROLLED
SUBJECT TO
WITH OUT

WORK

25325